

HI-LITE® ST™ PIN AND COLLAR AFTER ASSEMBLY

HI-LITE® ST™ PIN

SEE COLLAR STANDARDS FOR COLLAR STRENGTHS. LOWER STRENGTH (PIN OR COLLAR) DETERMINES SYSTEM STRENGTH.

FIRST DASH NO.	A DIA.	B REF.	D DIA.	TD DIA.	G REF.	H	R RAD.	S CHAMFER REF.	THREAD	INTERNAL THREAD LEFT HAND		DOUBLE SHEAR POUNDS MINIMUM	TENSION POUNDS MINIMUM
										T MAX	T1		
18	.905 .870	.770	.5927 .5917	.5550 .5500	.115 .200	.210 .200	.040 .025		9/16-18UNJF-3A Modified	.300	.456	69,200	43,500
20	.975 .940	.825	.6552 .6542	.6180 .6120	.130 .228	.238 .228	.040 .025		5/8-18UNJF-3A Modified	.300	.456	84,500	54,600

GENERAL NOTES:

- Concentricity: "A" to "D" diameter within .010 FIR.
- Dimensions to be met after finish.
- Surface texture per ANSI B46.1.
- Hole preparation per NAS618.
- Lead radius must be tangent to "D" diameter at max grip.
- Oversize replacement for HPL822 and HPL832.

CODE: First dash number indicates nominal diameter in 1/32nds of the pin which HPL842 oversize pin replaces.
Second dash number indicates maximum grip in 1/16ths.
See "Finish" note for explanation of code letters.
Code letter "A" following second dash number indicates assembly with HPM pull mandrel.

MATERIAL: Nickel Base Alloy per AMS5662.

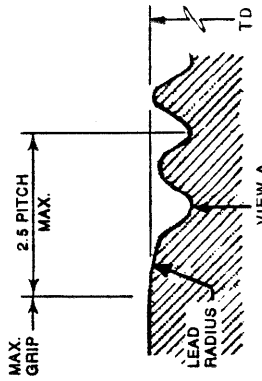
HEAT TREAT: 125,000 psi shear minimum.

FINISH: HPL842DL(-)(-) = Kalgard FA or EM620C solid film lube per MIL-L-46010, Type 1 and cetyl alcohol lube per Hi-Shear Spec. 305.
HPL842AG(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, with color code orange on the thread end and cetyl alcohol lube per Hi-Shear Spec. 305.
HPL842AP(-)(-) = Hi-Kote 1 aluminum coating per Hi-Shear Spec. 294, and cetyl alcohol lube per Hi-Shear Spec. 305.

SPECIFICATION: Hi-Lite Product Specification 391.

HOW TO ORDER EXAMPLES:

Pin Part Number Only
HPL842DL 18-8A
L Assembled with HPM Pull Mandrel (Optional)
L 8/16 or 1/2 Maximum Grip Length
L 18/32 or 9/16 Nominal Diameter Pin
Finish
Pin Part Number



VIEW A
HI-LITE THREAD TRANSITION AREA
THIS AREA OF SPECIAL CONFIGURATION AND COLD WORKING TO MEET PHYSICAL REQUIREMENTS. SEE SPECIFICATION FOR INSPECTION.

DRAWN	DATE	TITLE
J.F.Obispo	8-8-95	HI-LITE® ST™ PIN
APPROVED	DATE	PROTRUDING TENSION HEAD
J. Reusch	8-9-95	NICKEL BASE ALLOY (INCONEL 718)
REVISION	DATE	SPECIAL THREAD
1	J.F.Obispo 12-5-96	1/16" GRIP VARIATION, 1/32" OVERSIZE DRAWING NUMBER

U.S. Patents 4,326,825; 4,485,510 and 4,957,401.
Other U.S. and foreign patents pending.
"Hi-Lite" is a registered trademark and "Hi-Lite ST" is a trademark of Hi-Shear Corporation.